



FIG. 1

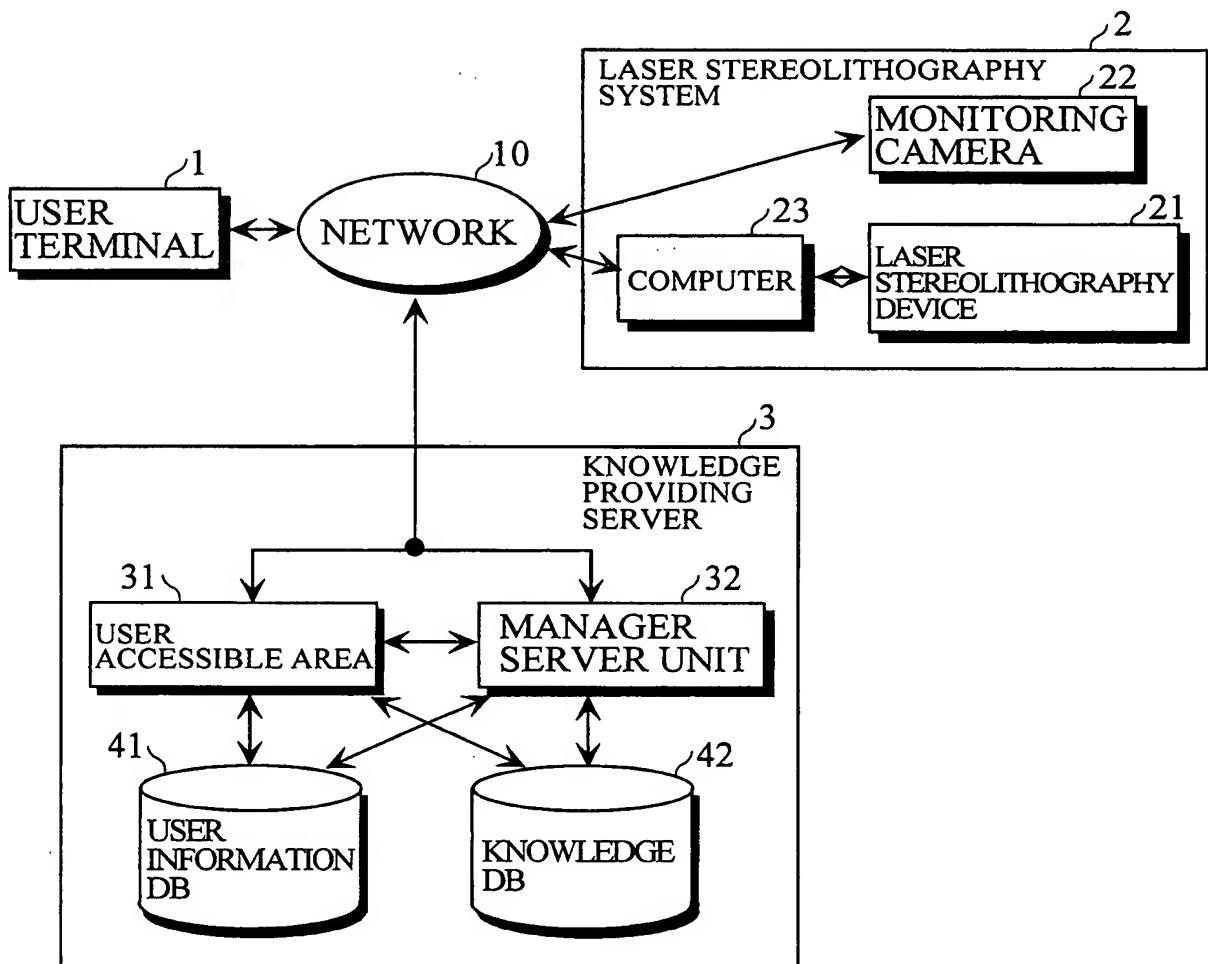


FIG. 3

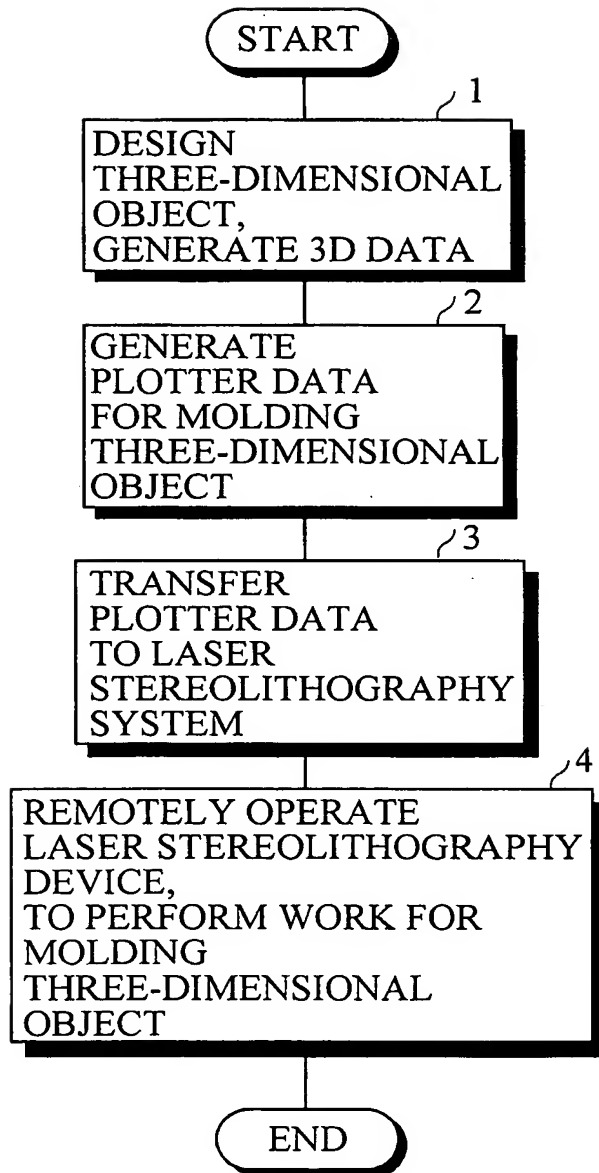


FIG. 4

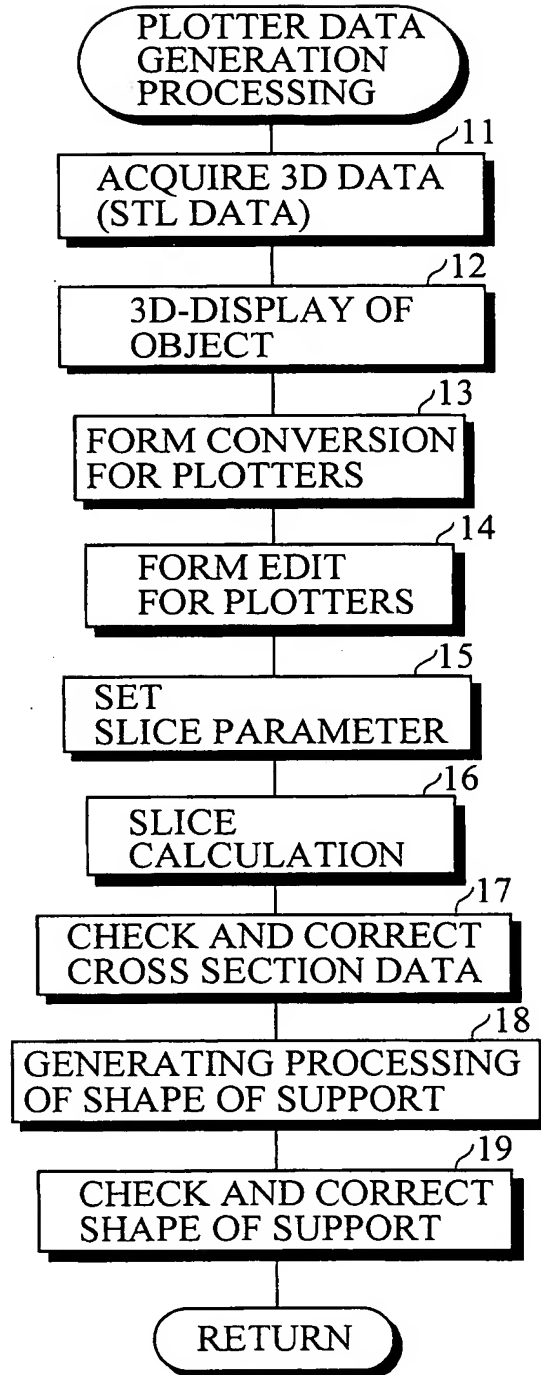


FIG.5

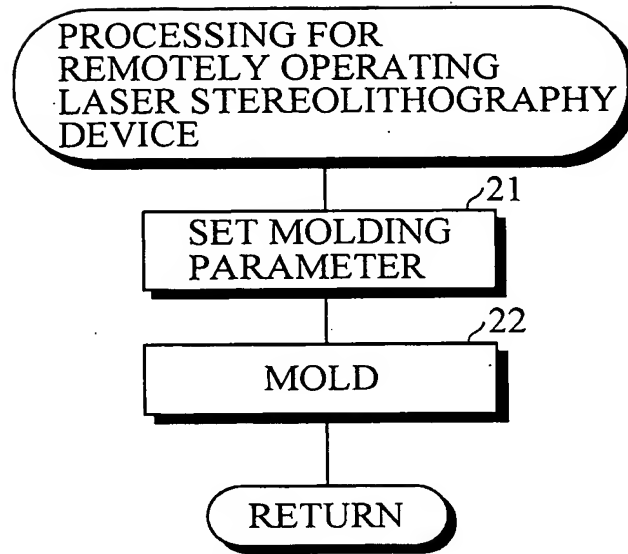


FIG.6

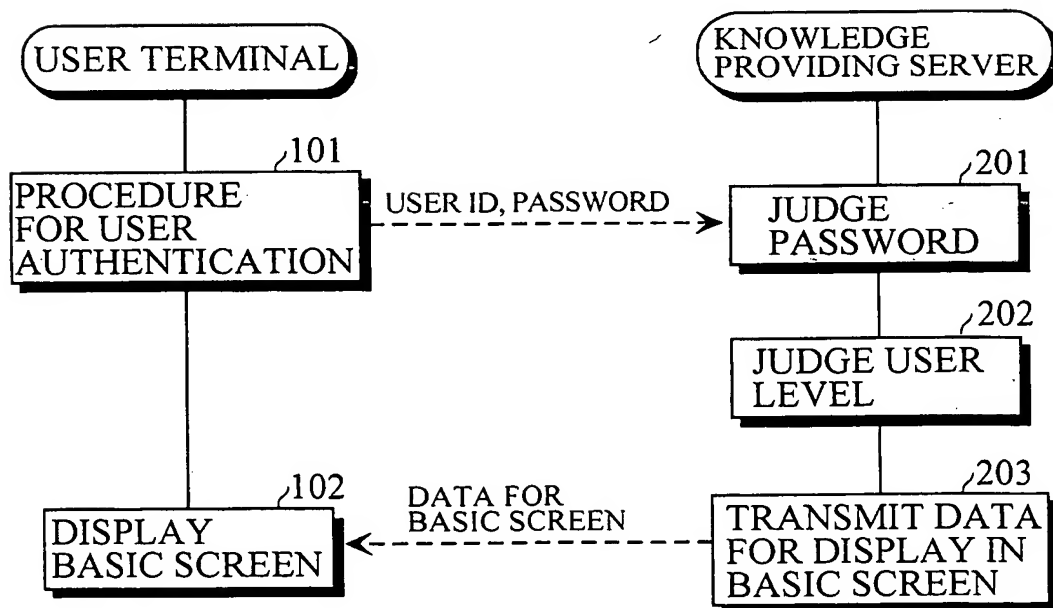


FIG.7

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)

RETURN

ADDRESS

USER ID

PASSWORD

OK

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)	
RETURN	
ADDRESS http://xxxxxx/xxx.xxx	
<div style="border: 1px solid black; padding: 5px;"> <div style="display: flex; justify-content: space-between;"> USER NAME USER1 61 </div> <div style="display: flex; justify-content: space-between;"> LEVEL OF SKILL 1 62 </div> <div style="display: flex; justify-content: space-between;"> KNOW-HOW RETRIEVAL 63 </div> <div style="display: flex; justify-content: space-between;"> FAILURE CASE RETRIEVAL 64 </div> <div style="display: flex; justify-content: space-between;"> RETRIEVAL 65 </div> </div>	<p style="text-align: center;">TABLE OF CONTENTS</p> <p>CHAPTER 0 BEFORE WORK</p> <p>CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER</p> <p>CHAPTER 2 EDITING OF SHAPE FOR PLOTTER</p> <p>CHAPTER 3 SLICING</p> <p>CHAPTER 4 CROSS SECTION EDITING</p> <p>CHAPTER 5 AUTOMATIC MAKING SUPPORT</p> <p>CHAPTER 6 MANUAL MAKING SUPPORT</p> <p>CHAPTER 7 DATA TRANSFER</p> <p>CHAPTER 8 REMORT OPERATION</p> <p>CHAPTER 9 SETTING OF LIQUID SURFACE OF RESIN</p> <p>CHAPTER 10 MOLDING ARRANGEMENT</p> <p>CHAPTER 11 COATING PARAMETER SETTING</p> <p>CHAPTER 12 EXPOSURE PARAMETER SETTING</p> <p>CHAPTER 13 MOLDING REMOVAL</p> <p>CHAPTER 14 WASHING AND SUPPORT REMOVAL</p> <p>CHAPTER 15 SECONDARY CURING</p>

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CHAPTER 6	MANUAL MAKING SUPPORT
CHAPTER 7	DATA TRANSFER
CHAPTER 8	REMOPT OPERATION
CHAPTER 9	SETTING OF LIQUID SURFACE OF RESIN
CHAPTER 10	MOLDING ARRANGEMENT
CHAPTER 11	COATING PARAMETER SETTING
CHAPTER 12	EXPOSURE PARAMETER SETTING
CHAPTER 13	MOLDING
CHAPTER 14	REMOVAL
CHAPTER 15	WASHING AND SUPPORT REMOVAL
CHAPTER 16	SECONDARY CURING

FIG.9

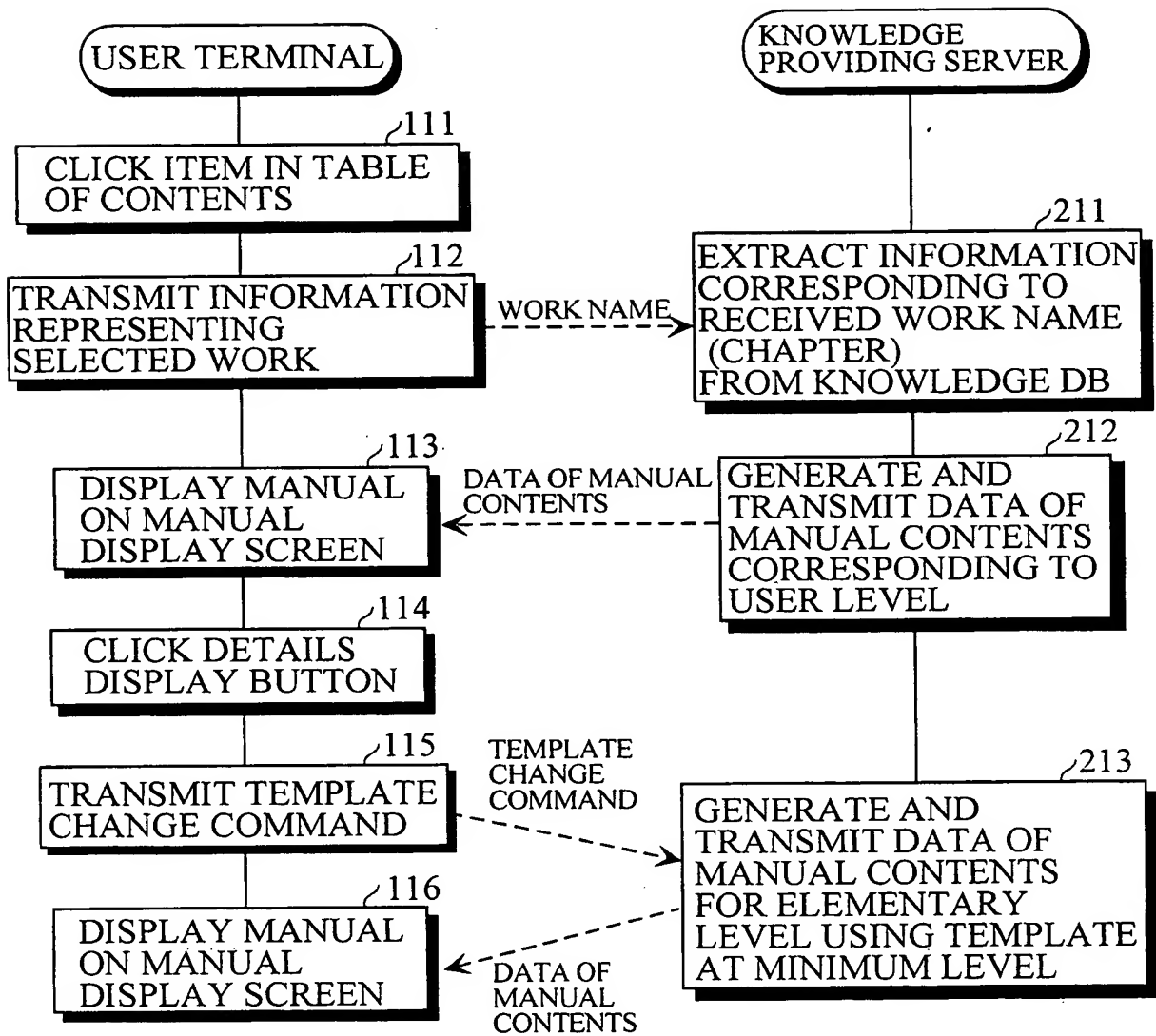


FIG.10

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)	
RETURN	
ADDRESS http://xxxxx/xxx.xxx	

<div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> USER NAME USER 1 LEVEL OF SKILL 1 KNOW-HOW RETRIEVAL 61 FAILURE CASE RETRIEVAL 62 RETRIEVAL 63 </div> <div style="border: 1px solid black; padding: 5px;"> TABLE OF CONTENTS CHAPTER 0 BEFORE WORK CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER CHAPTER 2 EDITING OF SHAPE FOR PLOTTER CHAPTER 3 SLICING CHAPTER 4 CROSS SECTION EDITING CHAPTER 5 AUTOMATIC MAKING SUPPORT CHAPTER 6 MANUAL MAKING SUPPORT CHAPTER 7 DATA TRANSFER CHAPTER 8 REMORT OPERATION CHAPTER 9 SETTING OF LIQUID SURFACE OF RESIN CHAPTER 10 MOLDING ARRANGEMENT CHAPTER 11 COATING PARAMETER SETTING CHAPTER 12 EXPOSURE PARAMETER SETTING CHAPTER 13 MOLDING CHAPTER 14 REMOVAL CHAPTER 15 WASHING AND SUPPORT REMOVAL CHAPTER 16 SECONDARY CURING </div>	<div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER 1_01 PLOTTER DATA EDITOR CONVERSION OF SHAPE FOR PLOTTER Select "① editing of a shape for a plotter" from an application menu in protter data editor. KNOW-HOW It is also possible to start plotter data editor from a start menu. </div> <div style="border: 1px solid black; height: 100px; text-align: center; line-height: 100px; margin-bottom: 5px;">IMAGE</div> <div style="border: 1px solid black; padding: 5px; margin-bottom: 5px;"> 1_02 STL DATA READING Specify and call an STL file to be converted from a file/registration menu in a window for converting a shape for a plotter. KNOW-HOW It is possible to convert a plurality of data at a time. </div> <div style="border: 1px solid black; height: 100px; text-align: center; line-height: 100px; margin-bottom: 5px;">IMAGE</div> <div style="border: 1px solid black; padding: 5px;"> 1_03 PROCESSING CONDITION SETTING Invert the name of a model to be edited, and push "editing/processing conditions setting" to confirm a unit. KNOW-HOW Generally, millimeter is a unit. Confirm because there is a case where inch or the like is a unit. </div> <div style="border: 1px solid black; height: 100px; text-align: center; line-height: 100px; margin-bottom: 5px;">IMAGE</div> <div style="border: 1px solid black; height: 100px; text-align: center; line-height: 100px;">IMAGE</div>
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DETAILS DISPLAY 65

FIG.11

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
<input type="button" value="RETURN"/>		<input type="button" value="DETAILS DISPLAY"/>	
ADDRESS <input type="text" value="http://xxxxx/xxx.xxx"/>			
USER NAME USER 3 LEVEL OF SKILL 3 61 KNOW-HOW RETRIEVAL 62 FAILURE CASE RETRIEVAL 64 63 <input type="button" value="RETRIEVAL"/>		CHAPTER 1 CONVERSION OF SHAPE FOR PLOTTER 1_01 PLOTTER DATA EDITOR CONVERSION OF SHAPE FOR PLOTTER Select "① editing of a shape for a plotter" from an application menu in protter data editor. 1_02 STL DATA READING Specify and call an STL file to be converted from a file/registration menu in a window for converting a shape for a plotter. 1_03 PROCESSING CONDITION SETTING Invert the name of a model to be edited, and push "editing/processing conditions setting" to confirm a unit. 1_04 START OF PROCESSING Execute conversion processing. 1_05 TERMINATION OF APPLICATION Select "the end of an application" from a menu, to perform termination processing.	
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FIG.12

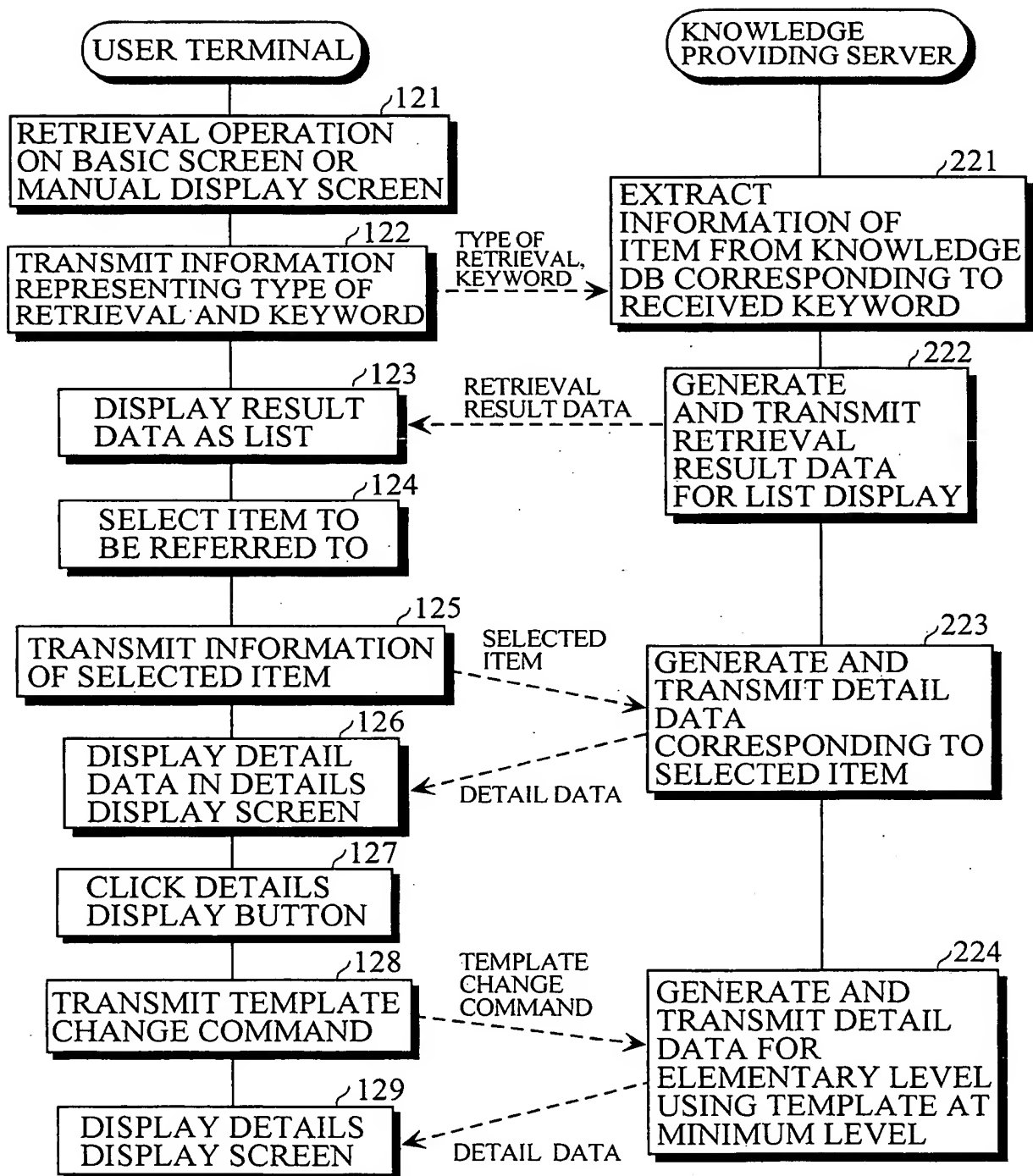




FIG.13

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)

⬅ RETURN

ADDRESS  http://xxxxxx/xxx.xxx 

LIST OF RESULTS

NUMBER OF CLAUSE	WORK NAME	PRECONDITIONS + KNOW-HOW
1_03	Processing Condition Setting	<u>Generally, millimeter is a unit.</u> <u>Confirm because there is a case where inch</u> <u>or the like is a unit.</u>

FIG.15

FILE(F) EDIT(E) DISPLAY(V) FAVORITE(A) TOOL(T) HELP(H)

RETURN

ADDRESS <http://xxxxxx/xxx.xxx>

LIST OF RESULTS

FAILURE	CAUSE
A molding time period is lengthened.	Because it takes long to perform exposure and coating per layer.
A knife is brought into contact with a model for a long time so that the model is liable to be destroyed when a molding time period is increased and the knife moves.	Because the distance a knife moves is increased, and the probability that the knife is caught by the model is increased.

Q Q

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FIG.17

